

Del 1.50 Work Order ID 85284

85284

Page 1

June-05-12 11:35:22 AM

Item ID: D3775-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Guard

Start Date: 05/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/05 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|----------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3775 | Rev B | | | | | | | | |
| 100 | DOOSAN LATHE | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Doosan | Memo | 0.00 | | | | | | | |
| Doosan Lathe | 1- Turn as per Folio FA742 Rev: _____ & Dwg D3775Rev: _____ 2-Deburr per dwg D3775 | | | | | | | | |
| | | | SA | 12718 | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | SA | 12718 | | | | | |
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | SA | 12/07/09 | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 85284

June-05-12 11:35:22 AM

85284

Page 2

Item ID: D3775-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Guard

Start Date: 05/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

12/7/11 (8)?

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

*CK 12/7/11**MF
12-09-10*

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NOTE: Date & initial all entries

Picklist Print

June-05-12 11:35:26 AM

Page 1

Work Order ID: 85284

85284

Parent Item: D3775-1

D3775-1

Parent Item Name: Guard

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 08-05-05 JLM Verified By:EC
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|

| | | | | | |
|----------------|--|-----------|--|----|--|
| MDEL RINR1.500 | | Purchased | | No | |
|----------------|--|-----------|--|----|--|

MDFI RINR1 500

Inventory

| Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | |
|-----|---|--------|-------|----------|--|--|--|
| 100 | f | 8.0000 | 0.235 | 1.978947 | | | |
|-----|---|--------|-------|----------|--|--|--|

**

SD 12/7/8

Location

MAT055

121971

Loc Qty

8

8

Loc Code

122042

2.024

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Dart Aerospace Ltd

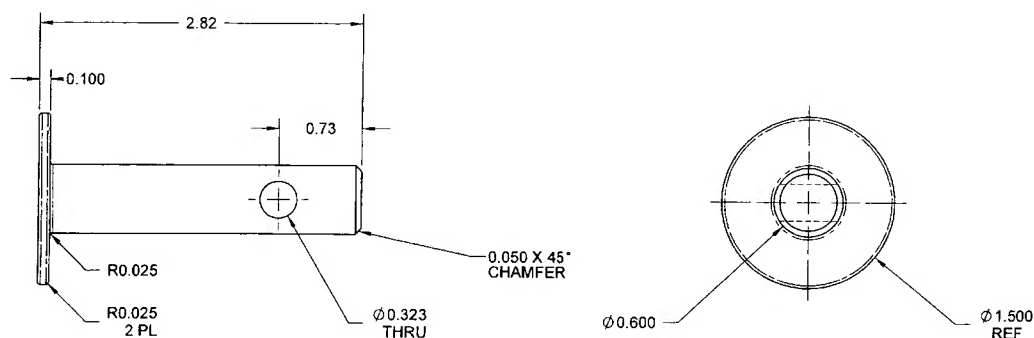
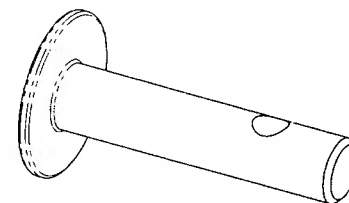
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85284/MJ

12/06/05

D3775-1 GUARD

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

| B | RE-DESIGN -1 FOR LONGER PROFILE. ELIMINATE -3 | HS | 08.06.10 |
|------------|---|----|----------|
| A | NEW ISSUE | HS | 08.06.04 |
| REV | DESCRIPTION | BY | DATE |
| DESIGN | HS | | |
| DRAWN | HS | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.06.10 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3775** REV. B
SHEET 1 OF 1
TITLE **GUARD** SCALE NTS

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